

Tuesday, 19/08/2008 4:07:29 PM
Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : 20 DEGREE COVER PLATE

Job Number : 41513-2

Estimate Number : 13384

P.O. Number :

Part Number : PB674300173

This Issue : 19/08/2008 S.O. No. :

Drawing Number : B6743001 PAGE26

Prsht Rev. : NC

Project Number : N/A

First Issue : / / Type : SMALL /MED FAB

Drawing Revision : B1

Previous Run : 40094

Material :

Written By :

Due Date : 18/09/2008

Qty: 30 Um: Each

Checked & Approved By : JUL 08.8.20

Comment : Est Rev:A 08-06-19 new issue DD verified by:ec

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0 M6061T6S032

6061-T6 Sheet 0.032"



HB 8-9-8



Comment: Qty.: 1.0692 sf(s)/Unit Total : 32.0765 sf(s)
6061-T6 Sheet 0.032" 18147
batch:

2.0 WATER JET

FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg B67-43001
Dwg Rev: B1
Prog Rev: B1 HB 8-9-8
****grain direction along 6.950" ****
2-Deburr if necessary HB 8-9-8



3.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



HB 8-9-8



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8

SECOND CHECK



Comment: SECOND CHECK

S 08/09/08 (x30) counter

5.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE
Bend as per Dwg B67-43001

S 09/09/11 (31)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 4:07:29 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 20 DEGREE COVER PLATE

Job Number: 41513

Part Number: PB674300173

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/15 (+31) counter

7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1
1- weld as per dwg B67-4300

SP 08.12.10

8.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1
1-grind weld flush

SP 08.12.10

9.0	QC10	VISUAL INSPECTION OF GROUND WELDS
-----	------	-----------------------------------



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/12/11 counter

10.0	QC5	INSPECT WORK TO CURRENT STEP
------	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

S 08/12/11 counter

11.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
------	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

M-L 08/12/12

12.0	POWDER COATING	POWDER COATING
------	----------------	----------------



Comment: POWDER COATING
Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

M 102316

(20X)

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*1=30
320 °F
2=00*

M-L 08/12/12

13.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
------	-----	---



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Fd 08/12/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: 19/08/2008 4:07:29 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 20 DEGREE COVER PLATE

Job Number: 41513

Part Number: PB674300173

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

PG

PURCHASING



710:8064



Comment: PURCHASING

SEND TO TALMAR FOR FOAM AND FABRIC

0209/01/26

(20)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

12/9/04

(20)

16.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

09/03/05 (x20)

center

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

50445

12/9/06

(7) + 13 mela

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(7)

12/09/06

MF 09-03-06

Job Completion



POSITIVE RECALL

EFFECTIVE 09/03/05 AUTH 4

RELEASED 4 DATE 09-03-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

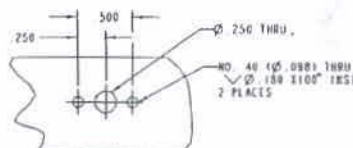
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

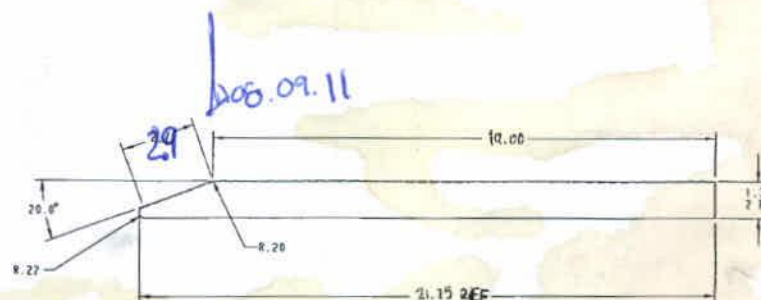
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

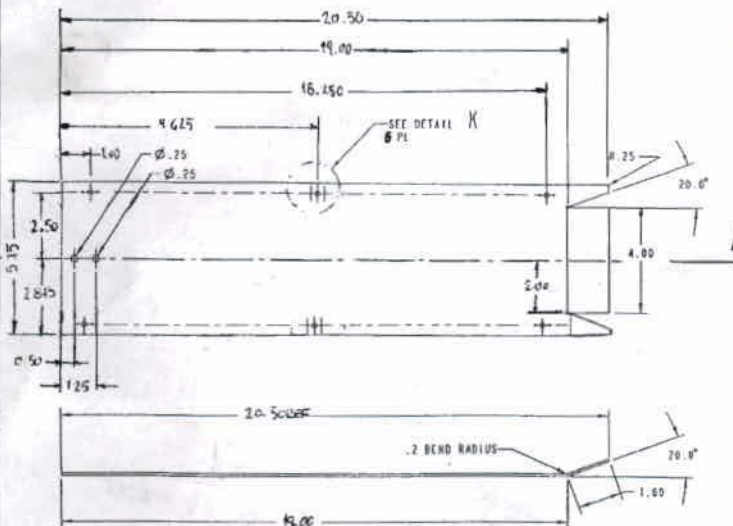
RELEASED
46 4 20



DETAIL K
SCALE 2.000
3 PL REF
3 PL REF



② -73 20 DEGREE COVER PLATE
MATERIAL: .032 THK, 6061-T6, 00-A-250/11
SCALE 0.500



② -159 SUPPORT PLATE
MATERIAL: .050 THK, 6061-T6, 00-A-250/11
SCALE 0.500

PART IS SYMMETRICAL ABOUT CENTER LINE

PREMIER AVIATION, INC.
2002 Aviation Parkway, Grand Prairie, Texas 75050
D05UVB B67-43001
REV. 20 43

ORIGINAL

NO 41513
WITHOUT NOTICE
WORK ORDER
ENGINEERING
RETURN TO
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

623
41 00
41 12
41 20
41 00

623

41 00

41 12
41 20

PACKING SLIP

TULMAR

Tulmar Safety Systems Inc.
 1123 Cameron Street
 Hawkesbury, ON K6A 2B8 CA
 Tel: 613-632-1282
 Fax: 613-632-2030
 MID : XOTULSAF1123HAW
 email: info@tulmar.com

Bill No:**Dart Aerospace**

1270 Aberdeen Street

Hawkesbury, ON K6A 1K7. Canada

COPY

Packing Slip No.

31791

Ship Date

4-Mar-09

Ship To:**Dart Aerospace**

1270 Aberdeen Street

Buyer: C Lavoie (613-632-9577)

Hawkesbury, ON K6A 1K7. Canada

613-632-9577

Order number	Sales order date	Account number	Account manager
22668	27-Jan-09	CDART100	Barney Bangs
PO number	Ship Via	PPD/COL	
PO00008064	Pick-Up		
Item No.	Quantity ordered	UOM	Qty Shipped/Returned
Description			Quantity on back order

8421-105

20

EA

20

Dart Blade Fold Kit - Pad #6/

Drawing No: (Ref B67-43001-73 Rev B1)

DWG Rev: A

Comments: Revised from SF 20093

Lot No: BATCH0000000004 Qty: 20

Sols/los

Shipper

Date:

MAR 04 2009

Certificate of Conformance☐ Not Applicable

I hereby certify that the items listed hereon have been inspected, tested and conform to all specifications and requirements detailed in the contract or purchase order. Objective evidence to support this statement is on file, and can be made available upon request.

If any questions or concerns, please contact QA Manager @ 613-632-1282 ext. 245.

Authorized Inspector _____

Date: 03/04/2009

FAXED
11-5-08

CLIFTON

Adhesive, Inc

Industrial Adhesives & Coatings

Date: 11/4/08

Shipper #: 11489

Certificate of Compliance

This letter certifies that 11 x 5 gallon pails of LA4009 Adhesive,
lot number (s) 08-294 was shipped to you on 11/4/08.

Clifton Adhesive, Inc manufactured this material according to internal specifications
which include quality control and assurance procedures. The material was
manufactured on 10/20/08 against your Purchase Order # 14986-00.

Shelf Life: 1 year from date of manufacture
Expiration Date: 10/20/09

This letter certifies that 5 x quart cans of CATUR Accelerator,
Lot number 08-305 was shipped to you on 11/4/08.

Clifton Adhesive, Inc manufactured this material according to internal specifications
which include quality control and assurance procedures. The material was
manufactured on 10/31/08 against your Purchase Order # 14986-00.

Shelf Life: 1 year from date of manufacture
Expiration Date: 10/31/09

Sincerely,

Daniel Constantino
Quality Assurance Mgr/ISO Coordinator

Burgess Place • Wayne, NJ 07470 USA
Phone: 973-694-0845 • Fax: 973-694-5678
www.cliftonadhesive.com

7122/24. (62)



J. ENNIS FABRICS LTD.

Wholesale Distributor of Textiles and Supplies

October 9, 2008

Fax To: Tulmar Safety Systems

Fax: 613-632-2030

Attention: Sandra Nadeau

Fax From: Sharon James

EDMONTON

HEAD OFFICE

12122 - 68 Street
Edmonton, AB T5B 1R1
Canada
Phone: (780) 474-5721

Certificate of Conformance

Re: PO 14881-00 for Oxford 7 Black

The goods shipped on P/O 14881-00 are as per sampled goods. Specification as follows:
As per mill documentation:

Oxford is in compliance with the following standards:

Width: Product is 58 Inches Wide.

Roll Size: Average Roll Length is 75 Yards.

Weight: Product Weight is 6.79 Ounces per Sq.Yd. /Product Weight is 10.94 oz per Lin.Yd

Content: 100% Nylon

Coating: Product has a Polyurethane Coating {approximately 0.65 oz/ Sq.Yd. (18.5g/sq.yd.)}

Denier: Yarn is 420 Denier.

Thread Count: Construction is 62 x 38 Threads per Square Inch

Protective Finish: Product is Water Repellent.

Hydro Resist: AATCC 127 (Suter): Average 800 mm

Manufacture Date: 08/06/08

Lot Number: 35896

Sincerely,
J. Ennis Fabrics Ltd.

S James

Sharon James
Product Development

CALGARY

2nd Floor, 337 - 17 Avenue SW
Calgary, AB T2S 0A5
Canada

VANCOUVER

13911 Bridgeport Road
Richmond, BC V6V 1J6
Canada

MONTREAL

8280 boulevard du Golf
Anjou, QC H1J 3A1
Canada

English: 1-800-66-ENNIS

Fax: (780) 479-6135
www.jennisfabrics.com

Français: 1-888-66-ENNIS

#1495/14

J ENNIS FABRICS LTD

OCT. 9. 2008 1:09PM

NO. 355 P. 2

frmGovernment

Page 1 of 2



American & Efid Inc.
Post Office Box - 507
Mount Holly, NC -28120

Test Report

Date : 1/26/2009

QLL No. 844

Mfg. Date : 1/12/2009

Quantity: 16.9

Lot Id : 566518

Product : Tex 90 BONDED 'Z' NYLON FILAMENT Black AA 63002 16 OZ

Specification : VT295E TPII CLA F BT92N4

Customer Order Number : 15245-00

Plys (Visual) : 4

Customer : Tulmar Safety

Twist Direction : Z

Shipped To : Tulmar Safety

A&E Color : 63002 Black
AA

Characteristic	Test1	Test2	Test3	Test4	Test5	Average	Minimum	Maximum
Strength #1 (Pound)	15.2	15.3	14.8	15.3	15.3			
Strength #2 (Pound)	15	14.9	15	15.1	15.1			
Average Strength (Pound)						15.1	11.8	
Elongation #1 (Percent)	21.9	22.4	21.3	22.3	22.1			
Elongation #2 (Percent)	21.8	21.5	22.3	21.9	21.7			
Average Elongation (Percent)						21.9		26
Twist S #1 (Turns per inch)	12.3							
Twist S #2 (Turns per inch)	12.3							
Average Twist S (Turns per inch) Initial Twist						12.3		
Twist Z #1 (Turns per inch)	8.2							
Twist Z #2 (Turns per inch)	8.2							
Average Twist Z (Turns per inch) Final Twist						8.2	5.5	
Yield #1 (Yards/Pound)	4077.2							
Yield #2 (Yards/Pound)	4126.1							
Average Yield (Yards/Pound)						4101.6	3600	5200

Shade Evaluation : GOOD
 Laundering : GOOD
 Perspiration : GOOD

frmGovernment

Page 1 of 2



American & Efid Inc.
Post Office Box - 507
Mount Holly, NC -28120

Test Report

Date : 1/26/2009

QLL No. 844

Mfg. Date : 1/12/2009

Quantity: 16.9

Lot Id : 566518

Product : Tex 90 BONDED 'Z' NYLON FILAMENT Black AA 63002 16 OZ

Specification : VT295E TPII CLA F BT92N4

Customer Order Number : 15245-00

Plys (Visual) : 4

Customer : Tulmar Safety

Twist Direction : Z

Shipped To : Tulmar Safety

A&E Color : 63002 Black
AA

Characteristic	Test1	Test2	Test3	Test4	Test5	Average	Minimum	Maximum
Strength #1 (Pound)	15.2	15.3	14.8	15.3	15.3			
Strength #2 (Pound)	15	14.9	15	15.1	15.1			
Average Strength (Pound)						15.1	11.8	

Elongation #1 (Percent)	21.9	22.4	21.3	22.3	22.1			
Elongation #2 (Percent)	21.8	21.5	22.3	21.9	21.7			
Average Elongation (Percent)						21.9	26	

Twist S #1 (Turns per inch)	12.3							
Twist S #2 (Turns per inch)	12.3							
Average Twist S (Turns per inch) Initial Twist						12.3		

Twist Z #1 (Turns per inch)	8.2							
Twist Z #2 (Turns per inch)	8.2							
Average Twist Z (Turns per inch) Final Twist						8.2	5.5	

Yield #1 (Yards/Pound)	4077.2							
Yield #2 (Yards/Pound)	4126.1							
Average Yield (Yards/Pound)						4101.6	3600	5200

Shade Evaluation : GOOD
Laundering : GOOD
Perspiration : GOOD

frmGovernment

Page 2 of 2

Wet Dry Cleaning :	<u>GOOD</u>
Light Test :	<u>GOOD</u>

I certify that the above test were performed under my supervision and in accordance with the specification test requirements and that the reported test results are true, valid and applicable to the samples tested. I further certify that these samples were the only samples tested from the lot of components identified above.

Signed : *Frank D. Munday*
Testing Director

Note

This Certificate of Compliance is the property of American & Efird Inc. and may not be reproduced except in it's entirety.

E.F. Walter Inc.	CERTIFICAT DE CONFORMITÉ CERTIFICATE OF COMPLIANCE		Approved <u>JR</u> Date <u>1/3/02</u>
Revision # 0	Revision date: January 30, 2002	Doc # F.7.5.5.A	Page 1 of 1

VENDU À
SOLD TO

6048

TULMAR SAFETY SYSTEMS INC.
1123 CAMERON STREET
HAWKESBURY ONT
K6A 2B8

Date : 07/15/2005

FOURNISSEUR
VENDOR

E.F. WALTER INC.
5000 HICKMORE
ST. LAURENT, PQ
H4T 1K6

Commande / Order # 10280

Notre / Our Reference # 37736

Nous certifions par la présente que la totalité du matériel inscrit ci-dessous a été inspecté et vérifié et est conforme aux devis et aux normes mentionnés sur votre commande.

We hereby certify that all of the material listed below has been inspected and tested and conforms to the drawings and / or specifications stated on your purchase order.

Item	Quantité Quantity	Piece # Part #	Description
742050004	10.00 SH		SC42 BLACK NEOPRENE UNTRIMMED 1/2" X 42" X 72' (NO SKIN) ASTM D1056 2A2
742012002	5.00 SH		SC42 BLACK NEOPRENE UNTRIMMED 1/8" X 42" X 72' (NO SKIN) ASTM D1056 2A2
			FLAME RESISTANCE
			SERVICE TEMP -40 DEG F TO +200 DEG F

Signé
Signed

[Signature] July 15, 2005

EC #1637-001/01 (C)

E.F. Walter Inc.	CERTIFICAT DE CONFORMITÉ CERTIFICATE OF COMPLIANCE		Approved <u>JR</u> Date <u>1/3/02</u>
Revision # 0	Revision date: January 30, 2002	Doc # F.7.5.5.A	Page 1 of 1

VENDU À
SOLD TO

6048

TULMAR SAFETY SYSTEMS INC.
1123 CAMERON STREET
HAWKESBURY ONT
K6A 2B8

Date : 09/09/2008

FOURNISSEUR
VENDOR

E.F. WALTER INC.
180 BARTOR ROAD
TORONTO, ONTARIO
M9M 2W6

Commande / Order # 14649-00

Notre / Our Reference # 55968

Nous certifions par la présente que la totalité du matériel inscrit ci-dessous a été inspecté et vérifié et est conforme aux devis et aux normes mentionnés sur votre commande.

We hereby certify that all of the material listed below has been inspected and tested and conforms to the drawings and / or specifications stated on your purchase order.

Item	Quantité Quantity	Pièce # Part #	Description
742050005	8.000 PCS	# 1637-001	SPONGE NEOPRENE BLACK SC42 TRIMMED NO SKIN (1/2" x 54" x 72") ASTM D1056, 2A2
			LOT # 75570 MANUFACTURING DATE: Sept. 5, 2008

Signé
Signed

09/09/2008

Tsc # 1637-001 / 02